

Work Order ID 137997

Monday, October 19, 2015 1:45:25 PM

Re print
137997

~~PRELIMINARY~~

DAS
9
9-89

Page 1

Item ID: D4364-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Run-on Landing Wearplate Aft

Stop *NS2*

Start Date: 10/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 10/19/2015

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4364	<u>Rev C</u>

150 0.00

150

Large Fab

Memo

0.02

Large Fab

1- Weld D4365-043 to wearplate as per dwg D4364
304 S.S. Welding Rod
BATCH #: m126014

3- Transfer drill holes in bar

x1 202 15-11-04

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

15-11-10

DAS
9
9-89

Work Order ID 137997

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137997

PRELIMINARY ISSUE

Page 3

Item ID: D4364-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplate Aft
 Start Date: 10/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>PRELIM</u>	0.00							
200									38
Packaging	Memo	0.00							9-89
Packaging	LOCATION : FP002								
									NOV 18 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

(12) of 1767190



JUL 10 2017

17/7/10

MUS

JAN 08 2016

POSITIVE RECALL
 POSITIVE RECALL
 EFFECTIVE _____ AUTH _____
 RELEASED _____ AUTH _____
 RELEASED _____ DATE 17-07-07
 9-89

Picklist Print

Monday, October 19, 2015 1:45:29 PM

PRELIMINARY ISSUE

Page 1

Work Order ID: 137997

137997

Parent Item: D4364-043

D4364-043

Parent Item Name: Run-on Landing Wearplate Aft

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC
REV:B 14.04.22 DWG B DD VERF:JLM
15.10.16 PER DWG REV.C1 DD VERF:JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4365-043		Manufactured	No				Each	0.0000		1			
D4365-043									**	x1	210	15-11-04	
Bar Weldment													
D4365-3		Manufactured	No			150	Each	2.0000	1	1			
D4365-3									**	x1	MR	15-11-04	
Bar													

Location

Loc Qty

Loc Code

WA001

2

127428

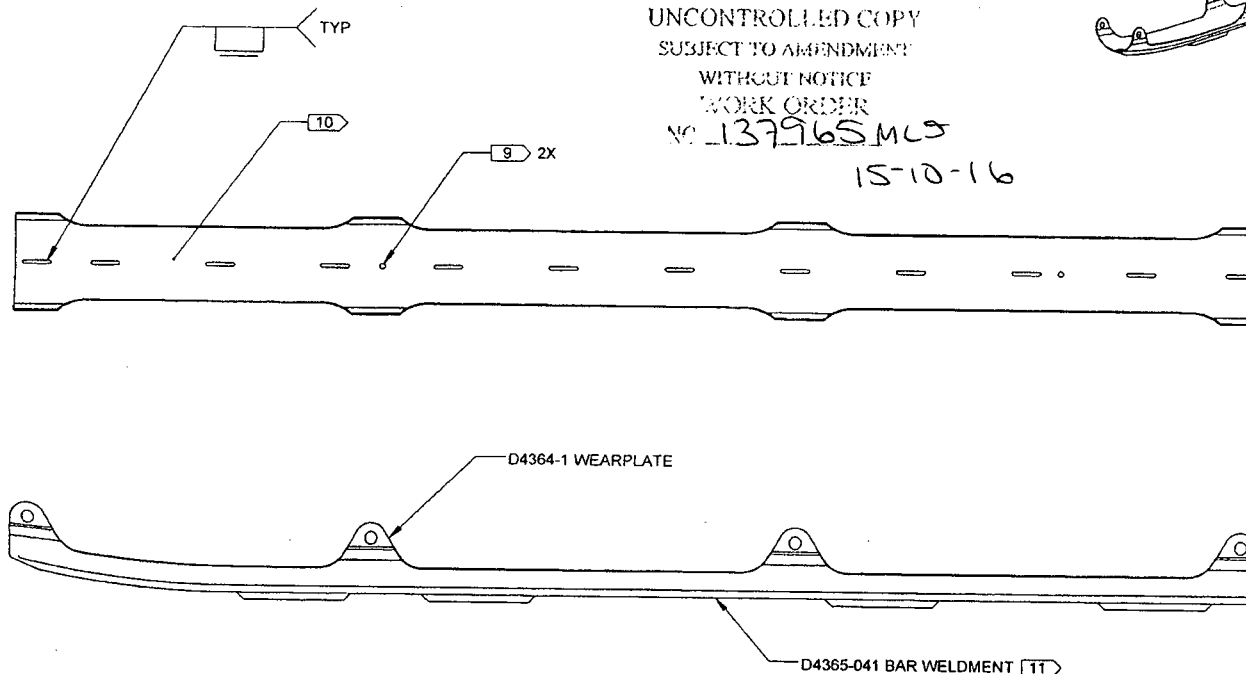
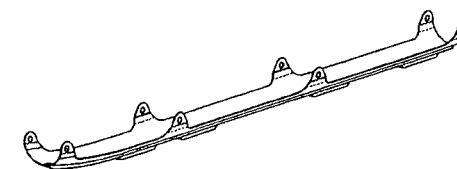
2

B129884 x 1

PRELIMINARY ISSUE

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-041	WEARPLATE ASSY
1	1	D4364-1	PLATE
2	1	D4365-041	BAR WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 137965ML9
15-10-16



D4364-041 FWD WEARPLATE ASSY

NOTES:

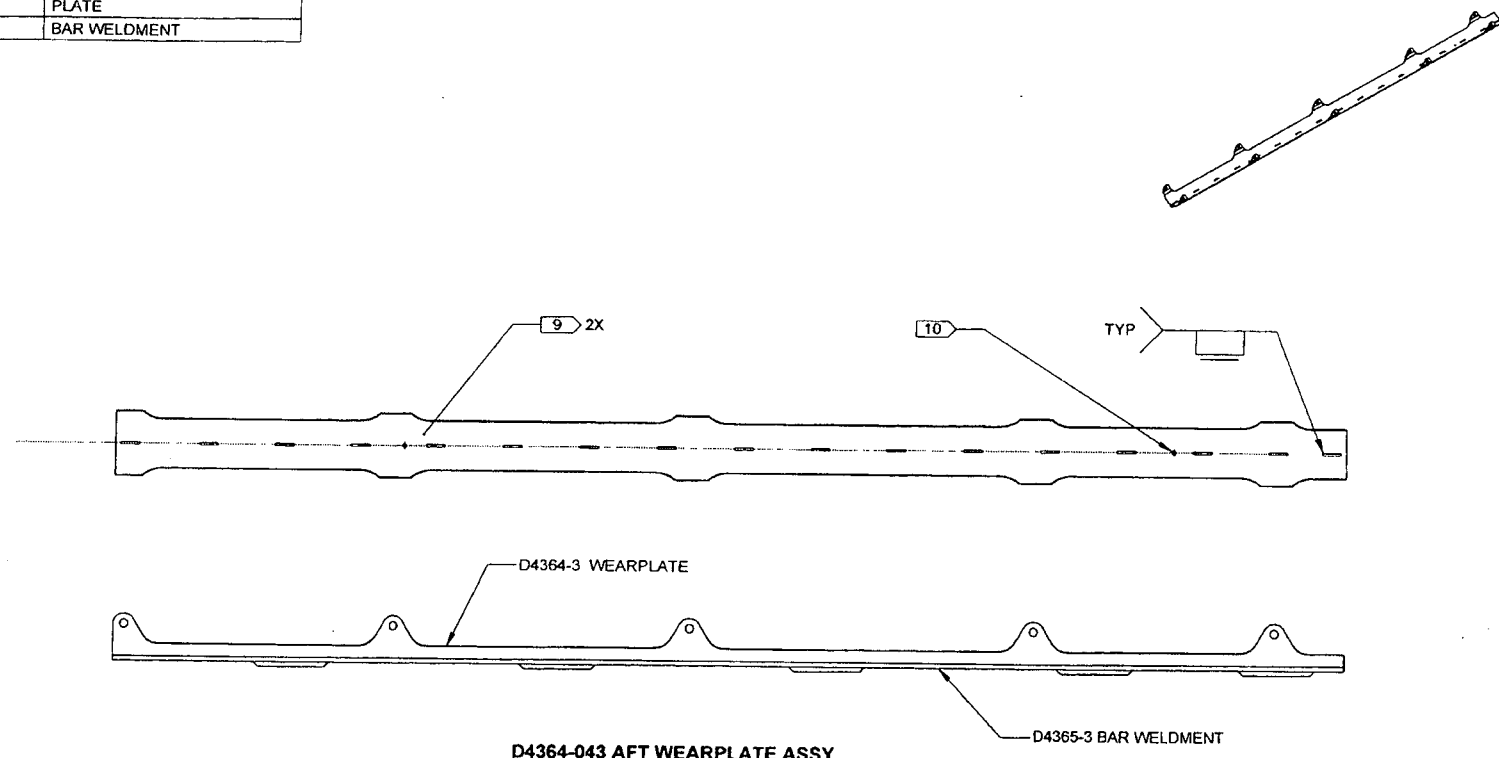
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-041" PER QSI 044 6.1
- 7) WEIGHT: D4364-041 = 4.95 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4365-041 BAR TO D4364-1 WEARPLATE AFTER WELDING
- 11) FORM TO MATCH PROFILE OF D4364-1 AT TIME OF WELDING

PRELIMINARY ISSUE

C	D4365-041 WAS D4365-1, D4365-043 WAS D4365-3, REMOVE 2059B HARDCOAT WELD	DB	15.09.18
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AJS	DRAWING NO.	REV. &
MFG. APPR.	DD	D4364	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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PRELIMINARY ISSUE

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-043	WEARPLATE ASSY
1	1	D4364-3	PLATE
2	1	D4365-043	BAR WELDMENT



NOTES:

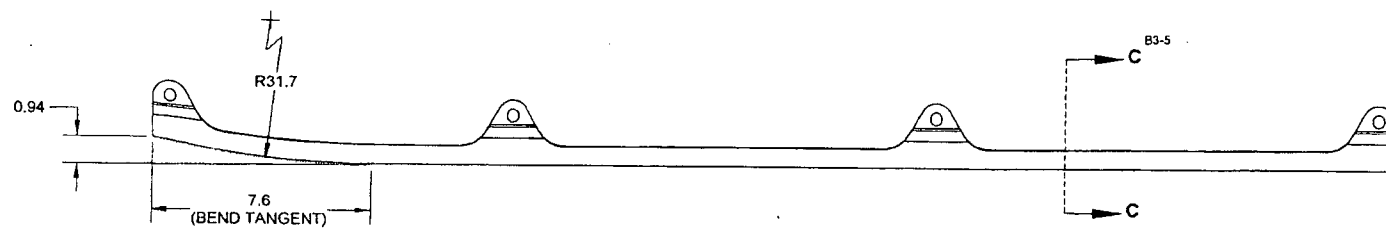
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-043" PER QSI 044 6.1
- 7) WEIGHT: D4364-043 = 7.03 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4365-043 BAR TO D4364-3 WEARPLATE AFTER WELDING

PRELIMINARY ISSUE

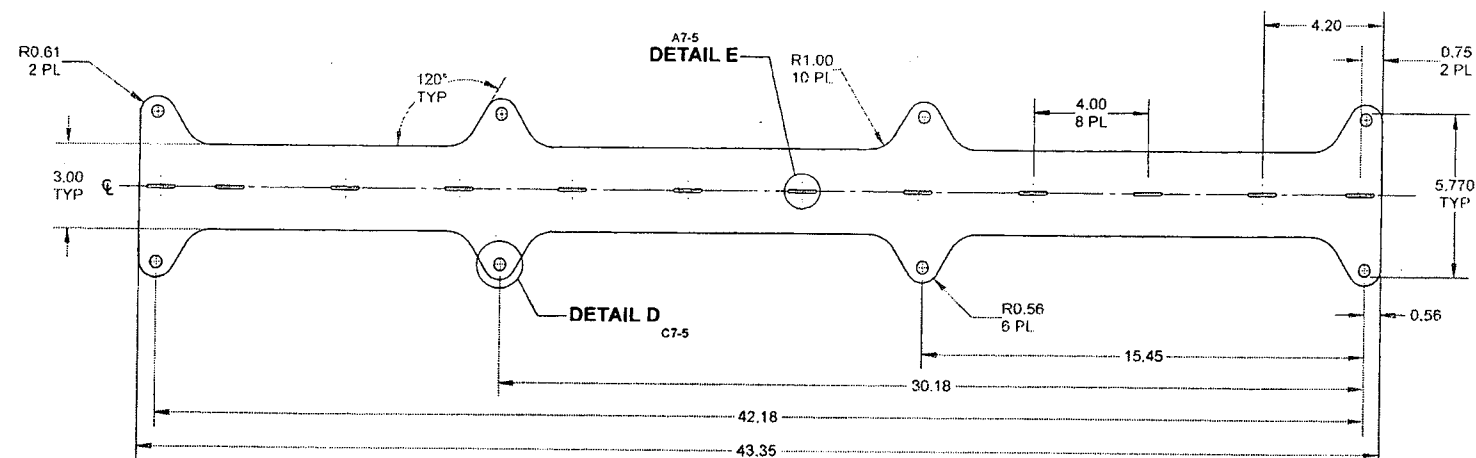
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DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. 2
MFG. APPR.	DD	D4364	SHEET 2 OF 5
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DE APPR.		WEARPLATE ASSY	NTS
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PRELIMINARY ISSUE

8 7 6 5 4 3 2 1



D4364-1 PLATE
(MAKE FROM D4364-1F)



D4364-1F PLATE
(FLAT PATTERN)

PRELIMINARY ISSUE

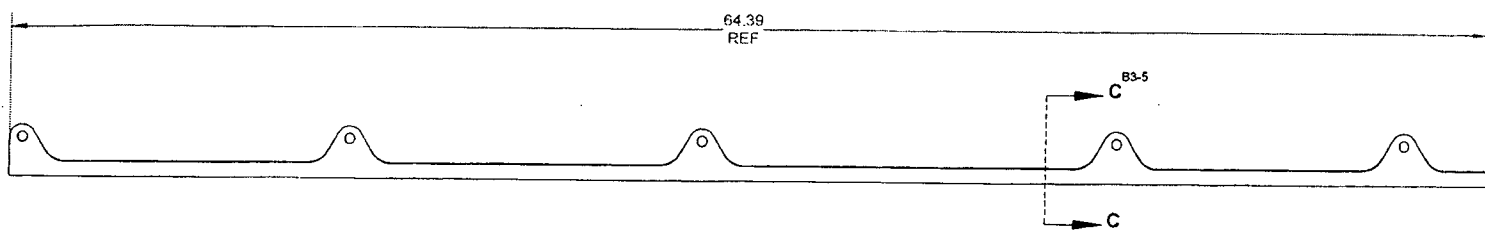
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	DD	D4364	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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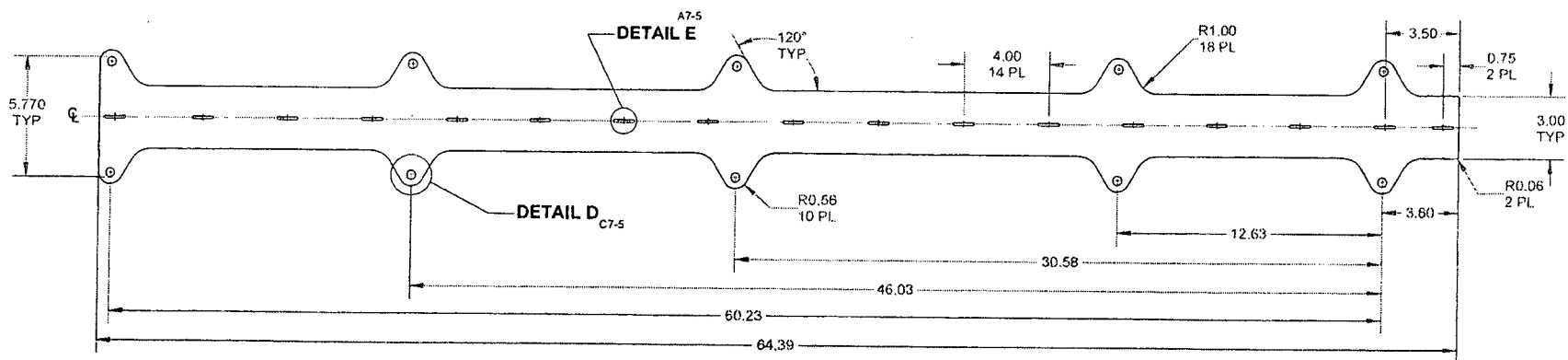
8 7 6 5 4 3 2 1

PRELIMINARY ISSUE

8 7 6 5 4 3 2 1



D4364-3 PLATE
(MAKE FROM D4364-3F)



D4364-3F PLATE
(FLAT PATTERN)

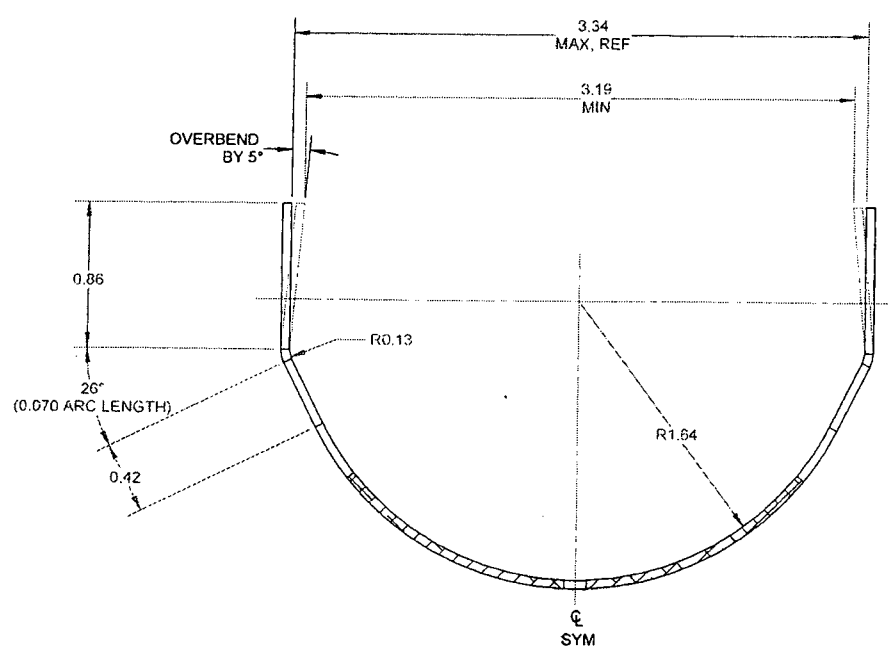
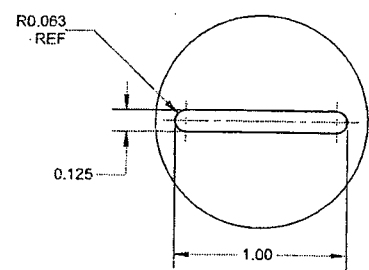
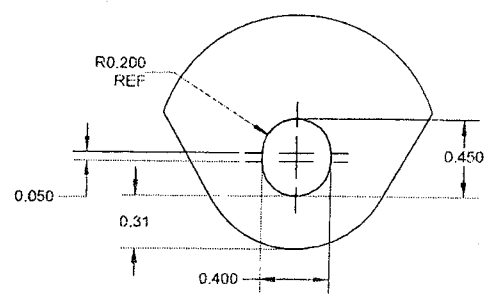
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.10 lbs

PRELIMINARY ISSUE

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CHECKED	AJS	DRAWING NO.	REV. &
MFG. APPR.	DD	D4364	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

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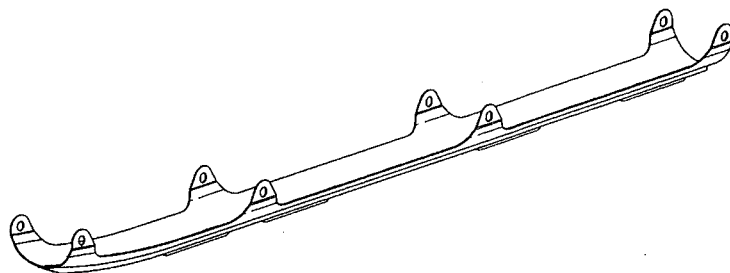


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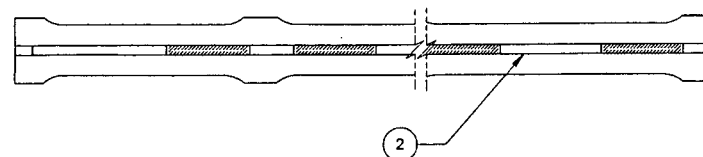
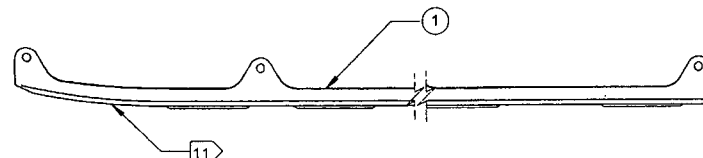
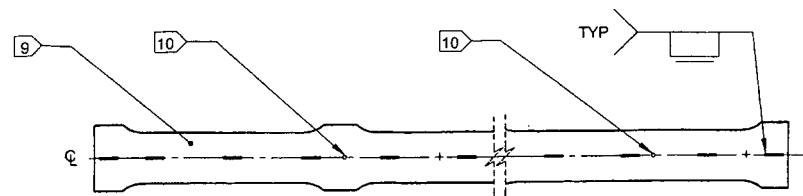
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DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	DD	D4364	SHEET 5 OF 5
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ITEM	QTY	P/N	DESCRIPTION
	X	D4364-041	FWD WEARPLATE ASSY
1	1	D4364-1	PLATE
2	1	D4365-041	BAR WELDMENT

△ C



D4364-041 FWD WEARPLATE ASSY △ C



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-041" PER QSI 044 6.1
- 7) WEIGHT: 4.03 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4365-041 BAR WELDMENT FROM D4364-1 WEARPLATE AFTER WELDING
- 11) FORM TO MATCH PROFILE OF D4364-1 AT TIME OF WELDING

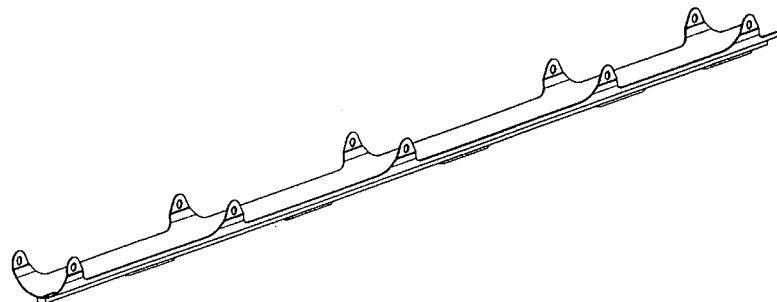
C	D4365-041 WAS D4365-1, D4365-043 WAS D4365-3, REMOVE 2059 HARDCOAT WELD (MOVED TO D4365), UPDATE TOLERANCES (SH 384), REMOVE VIEWS A-A, B-B (SH 2)	DB	16.01.21
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 1 OF 5
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2016-06-16
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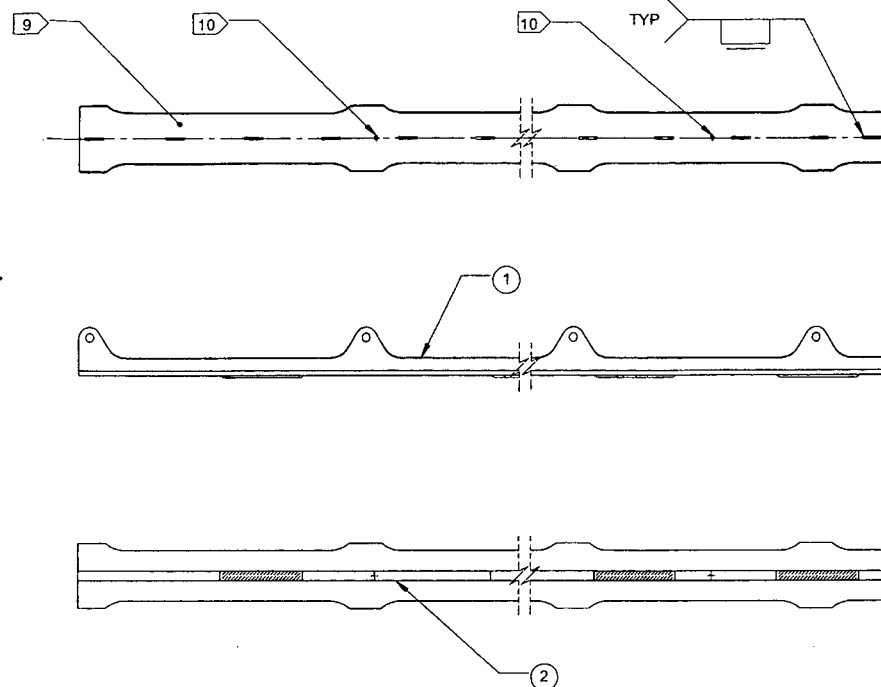
APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4364-043	WEARPLATE ASSY
1	1	D4364-3	PLATE
2	1	D4365-043	BAR WELDMENT

△ C



D4364-043 AFT WEARPLATE ASSY △ C



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-043" PER QSI 044 6.1
- 7) WEIGHT: 5.88 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4365-043 BAR WELDMENT FROM D4364-3 WEARPLATE AFTER WELDING

RELEASED
2016-06-16

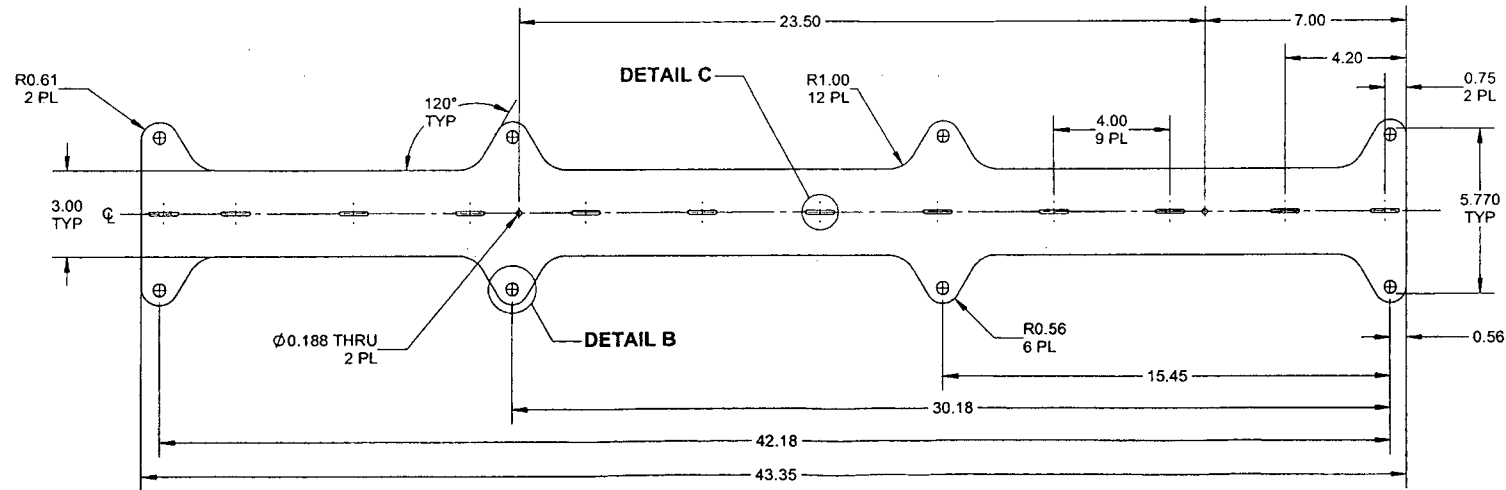
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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 2 OF 5
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8 7 6 5 4 3 2 1



D4364-1 PLATE
(MAKE FROM D4364-1F)



D4364-1F PLATE
(FLAT PATTERN)



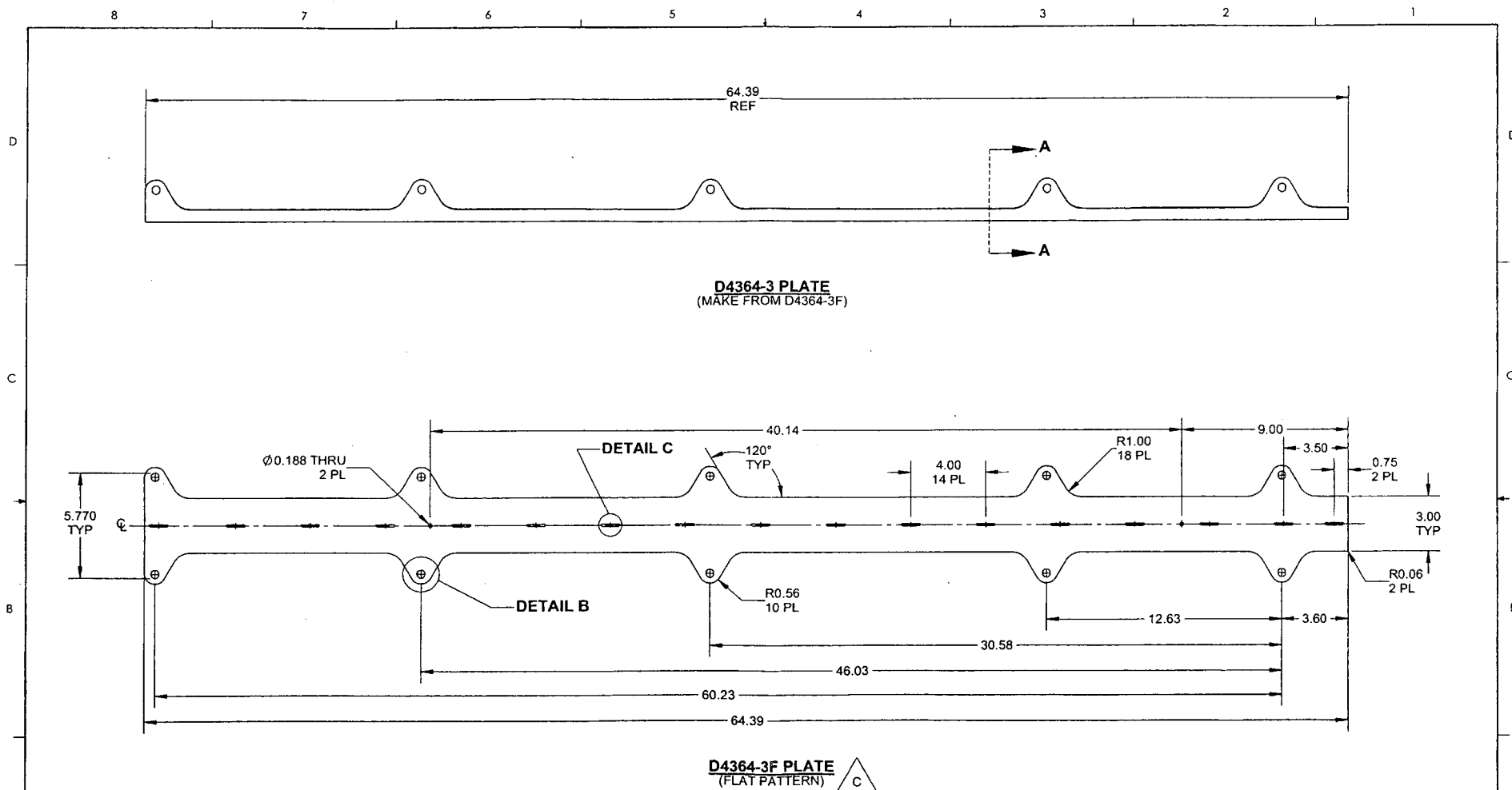
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.12 lbs

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2016-06-16

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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 3 OF 5
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DE APPR.	DS	WEARPLATE ASSY	NTS
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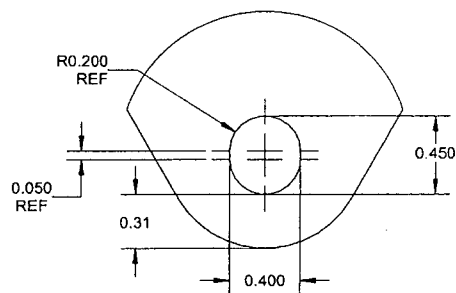


- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.10 lbs

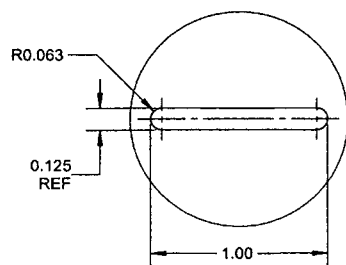
RELEASED
2016-06-16

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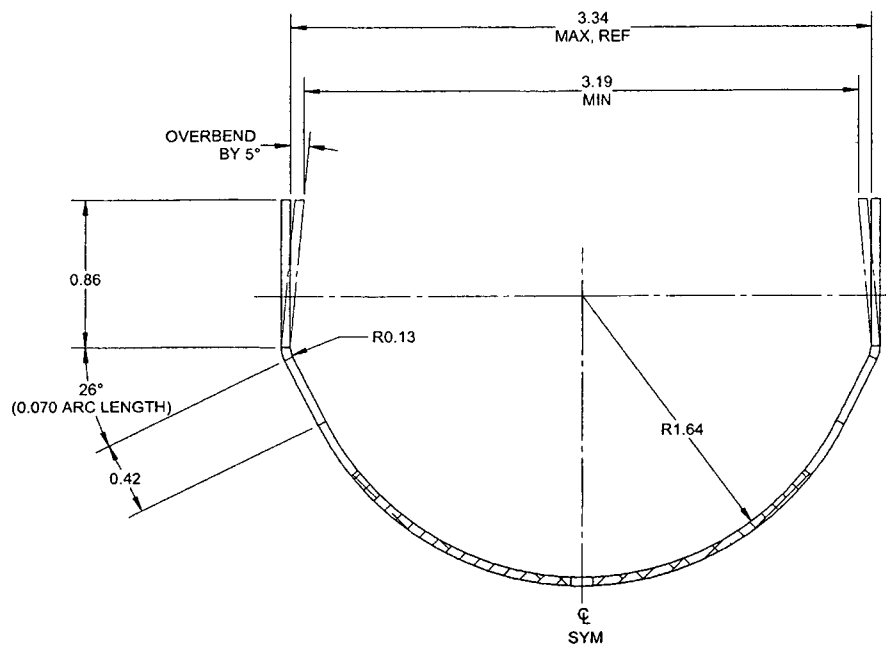
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 4 OF 5
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DE APPR.	DS	WEARPLATE ASSY	NTS
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DETAIL B



DETAIL C



SECTION A-A

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2016-06-16

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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 5 OF 5
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